

5/30

DART AEROSPACE LTD.	Work Order:	23801
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	12
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	XJ	05.07.14	12
2	MV	Make from D6101-007 billet for D2571 <b>Ensure that grain is along 7.75" length</b>			
		Batch No: B21818	JL	05.07.18	12
3	MV	Make from D6101-005 billet for D2572 <b>Ensure that grain is along 5.00" length</b>			
		Batch No: B23249	JL	05.07.18	12
4	MV	Fixturing W/O No _____ Fixturing Inspection last completed by _____	N/A		
5	MV	Program Batch No. 23801 Double check by: EC	EC	05/07/19	12
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	gml	05/07/25	12
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	gml	05/07/25	12
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	gml	05/07/25	12
9	MV	Machine keyway as per dwg D2571 & D2572	gml	05/07/25	12
10	MV	Deburr and remove all machining marks	gml	05/07/25	12
11	MV	Tumble for 20 minutes to remove sharp edges <del># 04.00.21</del>	gml	05/07/25	12
12	QC1	Inspect all dimensions to dimension sheets	gml	05/07/25	12
13	QC7	Second inspection	FC	05.07.25	12
14	FP	Acid etch and alodine as per QSI 005 4.1	PM	05/07/27	12
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	FC	05/08/03	12
16	QC3	Inspect Powder Coat	ML	05/08/04	12
17	ST	Identify and Stock.	CL	05/08/04	12
18	AC	Cost / Part 155.27 118.30	SUR	05.08.09	12
19	DC	Close W/O 163.00 131.15 Inspection Level 21	SG	05/08/05	12

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	gj

RELEASED  
02/10/15 RF